

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019034**Date Inspected:** 16-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

Notification no: 007370.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

1) SEG3020AP-001

2) SEG3020AQ-031

Notification no: 007378.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as

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OBG components. The weld designations MT inspected are as follows:

1) VP3005-001-014 to 026.

This QA Inspector observed the following work in progress:

OBG Seg 13CW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013M-073 [Longitudinal Diaphragm (LD) to I-rib stiffener, fillet weld at Panel Point (PP): 123]. The welder is identified as 045143 and was observed welding in the 2F position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-T-2132.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013M-096 [Floor Beam (FB) to I-rib stiffener, fillet weld at PP124]. The welder is identified as 037840 and was observed welding in the 4F position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1.

OBG Seg 13AW:

The FCAW process on weld joint no: SEG3013X-382 [LD to Bottom Panel (BP), CJP weld at PP119.35]. The welder is identified as 069043 and was observed welding in the 2G position. ZPMC QC was identified as Liu Da Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F.

The FCAW process on weld joint no: SEG3013M-214 [Plate Stiffener to FB, partial joint penetration weld (PJP) at PP118.35]. The welder is identified as 066912 and was observed welding in the 3G position. ZPMC QC was identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-2333-TC-P4F.

The FCAW process on weld joint no: SEG3013M-215 (Plate Stiffener to FB, PJP at PP118.35). The welder is identified as 201215 and was observed welding in the 2G position. ZPMC QC was identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-2332-TC-P4F.

The FCAW process on weld joint no: SEG3013E-165 (Plate Stiffener to FB, PJP at PP119.65). The welder is identified as 068917 and was observed welding in the 3G position. ZPMC QC was identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-2333-TC-P4F.

OBG Seg 13 BW:

ZPMC NDE personnel performing Ultrasonic Testing (UT) of CJP weld: SEG3014N-003 [Side Panel (SP) 3106 to SP3110 at PP122]. At six (6) locations on the weld are marked for repair. See attached photo for further information.

OBG Seg 14W:

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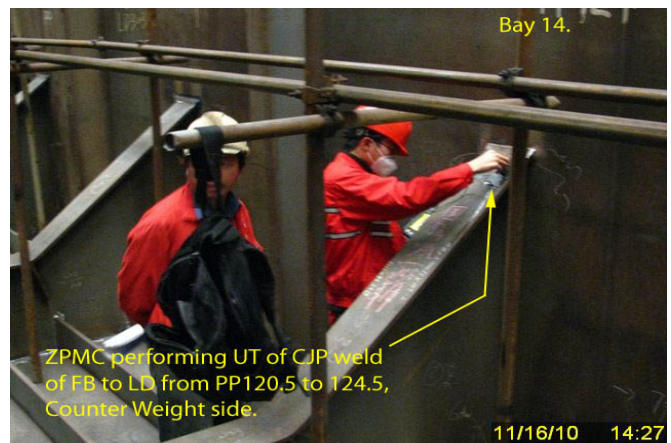
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ZPMC personnel doing fit-up of Floor Beam FB3334A and FB3339A with LD 3050A. See attached photo for further information.

OBG Seg 13BW and Seg 13CW:

ZPMC NDE personnel performing UT of CJP weld of FB to LD from PP120.5 to 124.5, Counter Weight side. See attached photo for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer